

Date: Tuesday, 3/11/2008 10:28:46 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR LH
Job Number : 37781	
Estimate Number : 11226	
P.O. Number :	Part Number : D32801
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D3280 REV <i>B C</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : THERMOFORMING	Drawing Revision : <i>B C</i>
Previous Run : 37104	Material :
Written By :	Due Date : 4/4/2008 Qty: 5 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM	
Est RevB 07.09.12 Thermoform in house DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F6006 701	lexan black
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*MLEXS093 F600602 2008/3/18*



Comment: Qty.: 4.0000 sf(s)/Unit Total : 20.0000 sf(s) *106751 B*  
lexan black *M 107291*

*→ P10 →*

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*B 08/03/12 X5*

3.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. *C*

Folio Rev. *B*

*B 08/03/12 X5*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*08/03/12 X5*

5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

*B 08/03/12 X5*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.03.12	1	Material Changed to MLEXS.093 F600602.	DL	08.03.12	5	LE 08.03.13	08/03/12

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 10:28:46 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR LH

Job Number: 37781

Part Number: D32801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

- 1) Check Surface finish for undesired marks, voids, dimples etc.
- 2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/03/17 X5

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/18 (X5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

272 8/3/18 50

(3X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/19

Job Completion



2008/3/18

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37781
<b>Description:</b> R22 Floor Protector, LH		<b>Part Number:</b>	D3280-1
<b>Inspection Dwg:</b> D3280 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BP      Date: 08/03/12

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.3	+/-0.100	18.25	✓			
16.0	+/-0.100	15.9	✓			
12.1	+/-0.100	12.05	✓			
0.95	+/-0.030	0.969	✓			
0.25	+/-0.030	0.248	✓			

Measured by: DR      Date: 08.03.13

Audited by: [Signature]      Date: 08/03/13

Prototype Approval: N/A      Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DL <u>[Signature]</u>	<u>[Signature]</u>



